

Date: Tuesday, 06/05/2008 8:55:30 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	A119 STEP INSTALLATION R/H	
Job Number :	39068	Part Number :	D119675012	
Estimate Number :	10132	Drawing Number :	IIN 119-675 REVB	
P.O. Number :		Project Number :	N/A	
This Issue :	06/05/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	B	
First Issue :	11	Type :	LARGE FAB ASSY	
Previous Run :	36579	Material :		
Written By :		Due Date :	30/05/2008	Qty: 5 Um: Each
Checked & Approved By :	JLD 08.5.07			
Comment :	Est Rev:D Removed Manufacturing JLM 05-11-01 Est Rev:E change to rev.b as per ECN1107 DD verified by:			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	39068A	A119 STEP WELDMENT RH



39068A



Comment: Sub-Component A119 STEP WELDMENT RH

SQ

2.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPP 119-675-012 CHG003

JLD 08.5.07

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick: Packing Kit

4.0	D2182B032	Rubber Cushion
-----	-----------	----------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Pick:Packing Kit

Qty	Part Number	Description	Batch
4	D2182B032	Rubber Cushion	

~~39068A~~
 35769

JLD 08/05/08 (X5)

5.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Pick:Packing Kit

Qty	Part Number	Description	Batch
8	D2274	Radius Block	

37630

JLD 08/05/08 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/05/08	#4 Aug	Please indicate in this manner. 4xD 2732-032 (4x 3.2" per unit)					cel/08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 8:55:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 39068

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26173

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D2617-3 Bushing

B29991

AS 08/05/08 (5)

7.0

D26175

Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 D2617-5 Bushing

B39082

AS 08/05/08 (5)

8.0

D2732032

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Qty Part #

Description

Batch

4 D2732-032

Rubber cushion

B374032

AS 08/05/08 (5)

9.0

D30411

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3041-1 Clamp

3833x14

B35978x6

AS 08/05/07 (5)

10.0

D30413

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

2 D3041-3 Clamp

35979

AS 08/05/07 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 8:55:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 39068

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D30421

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 D3042-1 Clamp 30891 X3
35982 X17

JS 08/05/07 (X5)

12.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

8 AN4-12A Bolt M105743

JS 08/05/07 (X5)

13.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-11A Bolt 104214

JS 08/05/07 (X5)

14.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt M107321

JS 08/05/07 (X5)

15.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M107321

JS 08/05/07 (X5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 8:55:30 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP INSTALLATION R/H

Job Number: 39068

Part Number: D119675012

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M106051

1 paperwork package from Step 1

JS 08/05/07 (X5)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/05/08 (X5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-675-012

Location: C

8/5/22

SQ

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/23 JJ

Job Completion



OK from David
for Rubber Cushion Qty
MF 08-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 <i>HELI-ACCESS-STEP™</i> , LH	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 <i>HELI-ACCESS-STEP™</i> , RH	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39068

• COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: **B**
Date: 07.10.23